

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014096**Date Inspected:** 11-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping, Yu Qi Guo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY11

TOWER STRUT PLATE

SMAW welding of weld joint 47A located on SD1-STSA4-5-123M-1.

Welder is identified as 040619. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

SMAW welding of weld joint 6A located on WD1-STSA4-5-143M-1.

Welder is identified as 040656. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

WEST TOWER LIFT 4, FIT LUG AT AE CORNER

FCAW welding of weld joint 109 located on WSTL4-4G/L.

Welder is identified as 040704. ZPMC QC is identified as Mr. Yuan Wen Jie.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

The welding variables recorded by QC appeared to comply with WPS-B-T-2333-Tc-P4-F.

FCAW welding of weld joint 39 located on WSTL4-4H/L.

Welder is identified as 049220. ZPMC QC is identified as Mr. Yuan Wen Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-4333-Tc-P4-F.

BEARING STIFFENER ON WD1-A25 SHEAR PLATE

FCAW welding of weld joint 26 located on WD1-A25B/E.

Welder is identified as 053316. ZPMC QC is identified as Mr. Shao Hui Long.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F.

BAY 10

BEARING STIFFENER ON ED1-A27 SHEAR PLATE

FCAW welding of weld joint 41 located on ED1-A27B/E.

Welder is identified as 204868. ZPMC CWI is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F.

FCAW welding of weld joint 25 located on ED1-A27B/E.

Welder is identified as 052926. ZPMC CWI is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F.

BEARING STIFFENER ON ND1-A26 SHEAR PLATE

FCAW welding of weld joint 48 located on ND1-A26B/B.

Welder is identified as 040367. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F.

FCAW welding of weld joint 50 located on ND1-A26B/B.

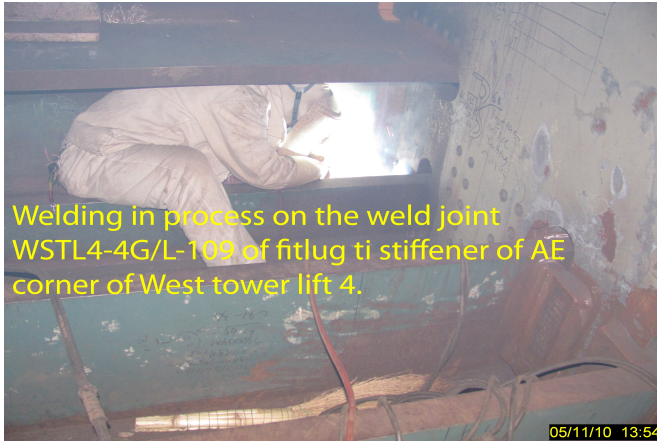
Welder is identified as 040432. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest : 15000422360, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Umesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer